

Resistant to intergranular – and pitting corrosion**GENERAL DESCRIPTION**

Stabilized stainless electrode for applications at higher temperatures (up to 400°C (750°F)).

Joining of austenitic stainless steel containing Molybdenum:

a) stabilized with Ti or Nb, as AISI 318, 316Nb, 316Ti, Wn° 1.4580, 1.4571, 1.4583, BS 320 S17, 320 S31, 320 S33, 318 S96, 318, C17

b) low carbon, as AISI 316, 316LN, Wn° 1.4401, 1.4436, 1.4449, 1.4404, 1.4435, 1.4438, 1.4406, 1.4429

Quiet arc, good control of the molten pool. No spatter.

If the weld metal has to be polished to a high degree, use Modi Lastek 804.

APPLICATIONS

Paint-industry, weaving-mills, photo-laboratories, food industry (dairy factories, breweries), constructions exposed to sea-water.

CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

C : < 0.04	Si : < 1.00	Mn : 0.70	Cr : 18.50	Ni : 11.50
Mo : 2.70	Nb : > 8 x % C			

MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)
≥ 400 MPa	≥ 590 MPa	≥ 30 %	≥ 47 J (20°C)

GENERAL INFORMATION

Welding positions	All, except vertical down		
Shielding gas	NA		
Packing	5 Kg in a plastic box		
Polarity	Ac or DC, reverse polarity (electrode positive)		
Diameter (mm)	2.0	2.5	3.2
Length (mm)	300	300	350
Approx. current (A)	25 - 40	50 - 70	60 - 90
Tips & Tricks	Very low amperage, short arc; use dry electrodes.		

The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.